

Work Order ID 74608

Monday, October 03, 2011 4:03:24 PM

Page 1

Item ID: D2939-2

Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle RH In, 206

Start Date: 10/3/2011 Start Qty: 6.00

Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-10-4

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2939

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

FK 12/03/14

6 0

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

FK 12/03/14

6 0

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

FK 12/03/14

6 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 10/3/2011 Start Qty: 6.00



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Required Date: 10/5/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

QC8- Inspect parts - second check

0.00



BA 12/03/15

6

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

6X8 m/l 12/03/15

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 2h20 ☐ OVEN TEMPERATURE: 320°F

FINISH TIME: 2h50

m120222

6

0

DP 12/03/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Required Date: 10/5/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>428A</u> Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

6x p Jel w/03/15

(6x) Sp 12-03-16

12/3/16

12-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 03, 2011 4:03:29 PM

Page 1

Work Order ID: 74608

Parent Item: D2939-2

Parent Item Name: Saddle RH In, 206


Start Date: 10/3/2011

Required Date: 10/5/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC
IPP Rev: C As per Rev C 07-03-19 JLM ☐ ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	4.0000	1	6			

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	4	
66965	1	
69677	2	
73768	1	
79586		

6 F.R. 12/03/13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74608
Description: 206 Saddle, Inboard, Right side		Part Number:	D29392
Inspection Dwg: D2939	Rev: C	DSK:	Rev:
			Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.116	.116	.116	.117	.117
B	0.100	0.140		.116	.116	.116	.116	.116
C	0.100	0.140		.118	.118	.116	.116	.117
D	0.210	0.230		.222	.222	.222	.222	.222
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.512	.512	.512	.512	.512
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.260	.260	.260	.260	.260
L	0.312	0.317		.314	.314	.314	.314	.314
M	0.235	0.240		.237	.237	.237	.237	.237
N	0.100	0.140		.120	.120	.121	.121	.121
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.498	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.720	2.760		2.740	2.740	2.740	2.740	2.740
S	0.240	0.270		.252	.252	.252	.252	.252
T	0.100	0.180		.135	.135	.135	.135	.135
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.250	1.270		1.2595	1.259	1.259	1.2595	1.2595
Y	1.565	1.585		1.573	1.573	1.573	1.573	1.573
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by:	F.K.	Date:	12/03/14
Audited by:	B.A.	Date:	12/03/15
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	7460
Description: 206 Saddle, Inboard, Right side		Part Number:	D2939-2
Inspection Dwg: D2939	Rev: C	DSK:	Rev:
			Page: 1 of 1

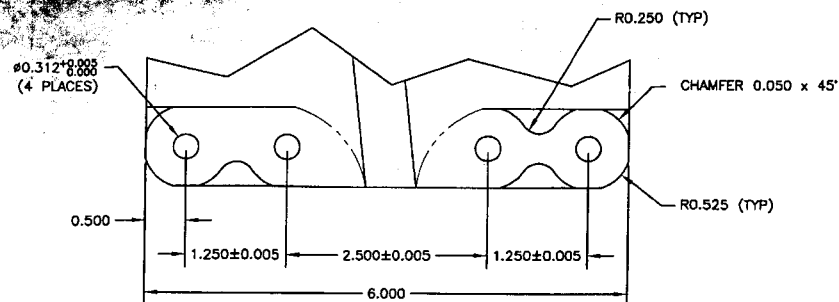
FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.117				
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C	0.100	0.140		.116				
D	0.210	0.230		.222				
E	1.245	1.255		1.250				
F	1.245	1.255		1.250				
G	2.495	2.505		2.500				
H	0.510	0.515		.512				
I	1.572	1.582		1.577				
J	2.495	2.505		2.500				
K	0.257	0.262		.260				
L	0.312	0.317		.314				
M	0.235	0.240		.237				
N	0.100	0.140		.121				
O	0.540	0.560		.550				
P	0.490	0.510		.500				
Q	3.715	3.725		3.720				
R	2.720	2.760		2.740				
S	0.240	0.270		.250				
T	0.100	0.180		.135				
U	1.625	1.635		1.630				
V	1.362	1.372		1.367				
W	0.316	0.321		.316				
X	1.250	1.270		1.259				
Y	1.565	1.585		1.573				
Z	0.178	0.198		.188				
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by: EK	Date: 12/03/14
Audited by: B.A	Date: 12/03/15
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD	

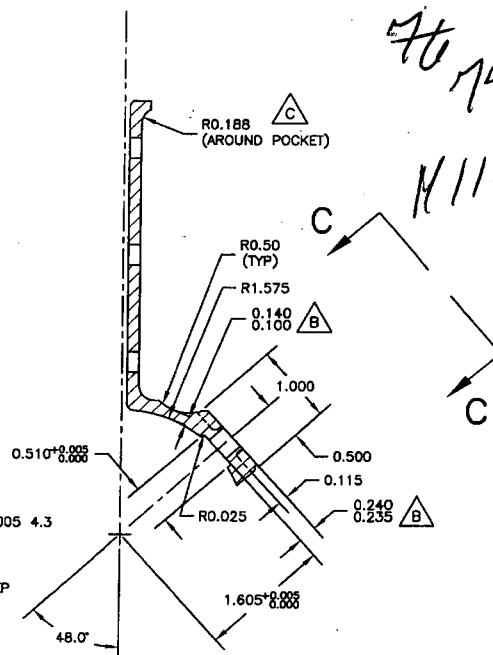


VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

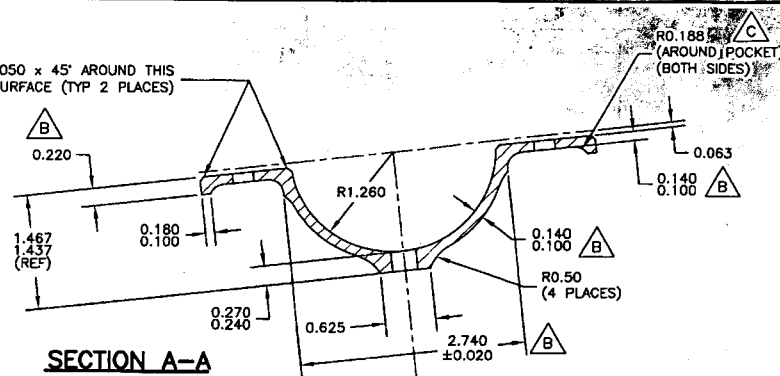
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

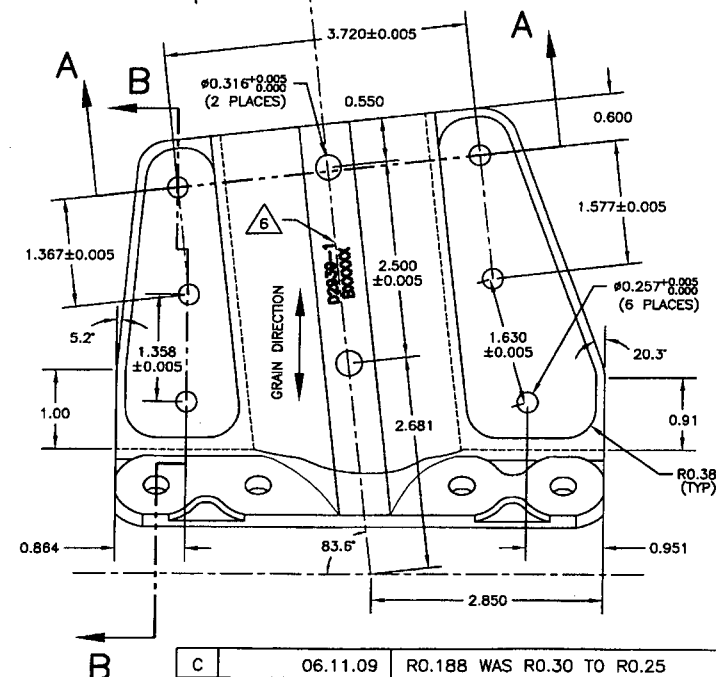


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED DEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE
		SADDLE INSIDE
		SCALE
		2:3

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DART DART AEROSPACE USA, INC. BELLEVILLE, WA

DRAWING NO. D2939
SHEET 1 OF 1
SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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